

Work Order ID 148748

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Item ID: D205-523-023 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 300 Hour Inspection
 Start Date: 7/6/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/7/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: SW Date: 7/6/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D205-523	Rev O								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Type labels per PPP D205-523-023	CHG 001							
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

SH 16-07-16
 DAS 27 9-89
 JUL 11 2016
 PC
 JUL 06 2016
 DAS 27 9-89
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-523-023								
	Location: FG121								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.03							
Quality Control									

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Picklist Print

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Work Order ID: 148748

148748

Parent Item: D205-523-023

D205-523-023

Parent Item Name: 300 Hour Inspection

Start Date: 7/6/2016

Required Date: 7/7/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-07-16 JLM

Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21042L6		Purchased				110	Each	231.0000	2	4			
MS21042L6									**	4		PC	
Nut													

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Location	Loc Qty	Loc Code
OVER007	100	
m134955	100	
ST303	131	
m133938	6	
m134055	5	
<u>m134676</u>	60	
m135058	60	

NAS1149D0663J

Purchased

No

110

Each

940.0000

2

4

NAS1149D0663J

Washer

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Location	Loc Qty	Loc Code
ST260	227	
M131618	227	
ST260a	500	
<u>M135135</u>	500	
ST263	176	
M133134	89	
M133769	12	
M134634	75	
ST269	37	
M126334	37	

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Work Order ID: 148748

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Parent Item: D205-523-023

D205-523-023

Parent Item Name: 300 Hour Inspection

Start Date: 7/6/2016

Required Date: 7/7/2016

Start Qty: 2.00

Required Qty: 2.00

D3012-1

Manufactured No

110 Each

5.0000

2 4

D3012-1

Decal

**

4

PC

Location

Loc Qty

Loc Code

ST014

5

140166

5

4

D3012-3

Manufactured No

110 Each

15.0000

2 4

D3012-3

Decal

**

4

PC

Location

Loc Qty

Loc Code

ST014

15

137526

5

140543

10

4

D3012-5

Manufactured No

110 Each

6.0000

2 4

D3012-5

Decal

**

4

PC

Location

Loc Qty

Loc Code

ST014

6

140116

6

4

AN5-14A

Purchased No

110 Each

34.0000

4 8

AN5-14A

Bolt

**

8

PC

Location

Loc Qty

Loc Code

ST338

34

m133990

9

m134943

25

8

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Parent Item: D205-523-023

D205-523-023

Parent Item Name: 300 Hour Inspection

Start Date: 7/6/2016

Required Date: 7/7/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0563J

Purchased

No

110

Each

1,421.000

8

16

NAS1149D0563.J

Washer

**

PC

Location

Loc Qty

Loc Code

GA	207
m125807	2
m133769	205
ST263	1115
m134497	315
m135058	800
ST269	99
m128257	99

16
8

DAS
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MS21042L5

Purchased

No

110

Each

495.0000

4

8

MS21042L5

Nut

**

PC

Location

Loc Qty

Loc Code

GA	81
m127813	81
OVER007	250
m134509	100
m134955	150
ST303	164
m134055	6
m134762	58
m135058	100

8

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25.4 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-523-013	3.5 lb 1.59 kg	±34.5 in ±0.876 m	±120.75 in-lb ±1.39 m-kg	116.8 in 2.97 m	408.8 in-lb 4.72 m-kg

25.5 PARTS LIST

-013	-023	-043	Part No.	Description
X			D205-523-013	HELI-RAPPEL™ INSTALLATION
	X		D205-523-023	300 HOUR INSPECTION KIT
1		X	D205-523-043	SLIDE BAR ASSEMBLY
		1	D3011-1	RAPPEL SLIDE BAR
		2	33116	STUD FITTING
	2	2	MS21042L6	NUT (OR MS21042-6)
	2	2	AN960JD616	WASHER
	2	2	D3012-1	DECAL
	2	2	D3012-3	DECAL
	2	2	D3012-5	DECAL
1			D2224	RAPPEL ANCHOR
2			D2229	DOUBLER
4	4		AN5-14A	BOLT
8	8		AN960JD516	WASHER
4	4		MS21042L5	NUT (OR MS21042-5)